



TECHNICAL DATA

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FUTURA-BOND 320 GEL EPOXY SURFACER/FILLER

Product Description

A two component, 100% solids epoxy surfacer/filler for filling and sealing porous or damaged concrete or other masonry surfaces. It provides a uniform chemically resistant surface for urethane and epoxy linings and coating systems.

Features

- 100% Solids.
- Zero VOC.
- Low odor.
- Convenient 1:1 mixing ratio.
- Excellent adhesion to a variety of concrete, masonry, brick and tile substrates.
- Helps reduce outgassing problems.
- Very good resistance to acids, alkalis and solvents.
- Hard tough surface with high impact resistance.
- Quick recoat time compared to cementitious repair compounds.
- Can fill holes up to ½ inch deep.

Recommended Uses

As a surfacer/filler for filling holes and patching corroded or damaged areas in poured concrete walls. It is ideal for resurfacing concrete block or porous concrete to give a smooth uniform surface. Helps reduce outgassing problems associated with coating concrete substrates.

Typical Properties

Solids by Volume	100%
Volatile Organic Compounds	0.0 lb/gal (0.0 g/l)
Theoretical Coverage	1604 ft ² @ 1 mil (3.8 m ² @ 1 mm)
Recommend DFT	Up to: ½ inch (12.7 mm)
Number of Coats	1
Mix Ratio (by volume)	1"A" : 1"B"
Flash Point (PMCC)	230°F (110°C)
Shelf Life @ 60-90°F (16-32°C)	12 months
Color	Clear

Chemical Resistance

Water	Excellent
Acids (under 25% Concentration)	Very Good
Alkalies	Excellent
Salts	Excellent
Solvents	Good
Petroleum & Vegetable Oils	Excellent

Ordering Information

Packaging:	2 gal & 10 gal kits
Shipping Weight:	9.3 lb/gal (1.1 kg/l)

APPLICATION INFORMATION

FUTURA-BOND 320 GEL

Surface Preparation

Remove all oil, grease or other contaminants from the surface to be coated in accordance with SSPC-SP 1.

Concrete: Must be cured a minimum of 28 days at 70°F (21°C) and 50% RH, or equivalent. Remove fins and other protrusions by stoning or grinding. Abrasive blast in accordance with SSPC-SP 13 or ASTM D4258 to open all surface voids and remove all form oils, incompatible curing agents, hardeners, laitance, other foreign materials and produce a angular surface texture similar to that of medium grit sandpaper. Blow or vacuum off abrasive and dust.

Mixing

Power mix each component separately, then combine at a ratio of 1 "A" to 1 "B" by volume and power mix to a smooth consistency.

Thinning

Do not thin.

Pot Life

Material Temperature	No Thinner
60°F (15°C)	3 hours
75°F (24°C)	2 hours
90°F (32°C)	45 min

Application Conditions

	Normal	Minimum	Maximum
Material	75-90°F (24-32°C)	65°F (18°C)	100°F (38°C)
Surface	75-90°F (24-32°C)	45°F (7°C)	110°F (43°C)
Ambient	75-90°F (24-32°C)	45°F (7°C)	100°F (38°C)
Humidity	30-50%	0%	85%

Note: Application to concrete and masonry when the surface temperature is falling and not rising will help minimize pinholing caused by outgassing.
Surface temperature must be at least 5°F (3°C) above the dew point>

Clean Up

Use MEK or a 1:1 mixture of MEK and Toluene.

Application

- **Apply directly to the concrete substrates only.**
- Do not apply over existing coatings.
- Do not apply to metal surfaces.
- Do not use to fill expansion joints, moving joints/ cracks or voids. Contact ITW Futura Coatings for specific recommendations.

Patching: Fill bug-holes and other areas over ¼ inch diameter and less than ½ inch deep with a non-sag paste made by mixing 1-2 parts (by volume) "silica flour" or "cabosil" into 5 parts of the FUTURA-BOND 320 GEL mix. Use a wide-blade knife or small trowel to press the paste into place. The surface may be smoothed, if desired by wetting the trowel or a small brush with Xylol. Let cure overnight to a firm surface before recoating.

Surfacing: Transfer the mixed material to the substrate by roller or trowel.

Wipe a 12" wide rubber bladed squeegee or steel trowel across the surface in an upward wedging action at a 45° angle, forcing the mixture into the pores and voids but leaving a small amount of the mixture on the surface.

Smooth any squeegee trowel marks or other imperfections with a brush slightly dampened with Xylene.

Cure Time

These times are based on a 30-50% RH. Excessive film thickness, cooler temperatures or inadequate ventilation will require longer cure times.

	Surface Temperature		
	50-69°F (10-21°C)	70-89°F (21-32°C)	90-110°F (32-43°C)
Surface dry	10-16 hours	6-8 hours	4 hours
Hard Film	24 hours	8-12 hours	4-8 hours
Recoat (min)*	16 hours	8 hours	4-6 hours
Recoat (max)	4 days	3 days	36 hours
Full cure	6 days	5 days	3 days

* Minimum recoat time may vary, depending on film thickness.

- If the material has exceeded its maximum recoat time or full cure time contact ITW Futura Coatings for recommended recoating procedures.

Safety Information

- Read the Material Safety Data Sheet (MSDS) and container labels for detailed health and safety information.
- Do not apply material in enclosed areas without adequate air exchange and ventilation.
- All application personnel must use respirators rated for organic vapors, or in confined spaces wear fresh air respirators or fresh air hoods.
- Wear protective clothing, gloves and eye protection.
- Breathing fumes or contact with the skin may cause severe allergic reactions.
- This product contains flammable solvents! Keep away from all sparks, flames and hot surfaces.
- **This product is intended for industrial use by properly trained professional applicators only.**

Storage Conditions

- Coatings need to be protected from moisture contamination. Store drums and pails in a dry location at 55-80°F (11-27°C).
- Materials must be kept above 50°F (10°C).

ITW FUTURA COATINGS, 1685 GALT INDUSTRIAL BLVD., ST LOUIS, MO, (314) 733-1110

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